



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001
Job Sheet 187483



7294

Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/5/18

Job Tracking No:

Due Date: 1/30/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Signature
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea		1/30/19	0.00	0.00	Start Up Stores/Pkg-1			JAN 01 2019
110	Packaging	1 pcs		1/30/19	0.00	0.00	Packaging1-1			JAN 4 2019
120	QC	1 pcs		1/30/19	0.00	0.00	QC4			JAN 21 2019
130	Packaging	1 pcs		1/30/19	0.00	0.00	Packaging3-1			JAN 21 2019
135	DC	1 pcs		1/30/19	0.00	0.00	DC			JAN 21 2019
140	QC21-FG	1 Ea		1/30/19	0.00	0.00	QC21			JAN 22 2019
Part Op 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____										
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4001										

Part Op 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____

Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5019004
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5136925
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5136931
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5132228
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5134734
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5093821
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5127925
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5136495
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	5131207
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5143377
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5081641
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5081639
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5022241
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	5049669
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5062766
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5038797
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	5042029
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	5050517
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	5082442
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5063780

Plex 12/5/18 12:48 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐													
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)											
Description Work Order Deviation				Disposition													
 Container No: S146149 Part: 646.4001 Job No: 187483 Serial No/Batch: S146149 Revision: _____ Inspector: _____ Exp Date: 06/20/2019 Instructions: FAA STC SR02180LA 14/09/07, 21, 26, STC SH09 -				Completed By													
				Lead hand / Supervisor													
				QC / QA Coordinator													
				MULT CATEGORY													
				<table><tr><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Off-set/Set-up</td><td></td></tr></table>				☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Tolerance	☐ Grain Direction	☐ Drawing	☐ Weld	☐ Finish	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Power Loss/Surge	☐ Positioned Wrong																
☐ Folio/Program	☐ Outside Tolerance																
☐ Grain Direction	☐ Drawing																
☐ Weld	☐ Finish																
☐ Wrong Stock Pulled	☐ Part Lost/Missing																
☐ Out of Sequence	☐ Misread																
☐ Off-set/Set-up																	
Human Factors ☐																	

2/5/2013

Job 187483. (607294)
[Dart Hawkesbury] Job Sheet - White, Jesse

646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	5082322
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5064802
646.3719	Doubler	2 Ea (2 ea)	90-Start up Operation	5063254
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation	5131074
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5070843
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation	5131076
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation	5131319
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5126854
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5041250
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5126897
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5041498
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5056998
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5133711
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	514359
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5092120x1
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5130322
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095479
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5098032
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation	5131193
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation	5112901
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5119258
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5133132
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5127332
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095478
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5127344x1 5095478x1
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation	5103962x10 5133179x10
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	5108538
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	5153848
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation	514134062
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation	5048892
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation	5123425
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5100409
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation	5132364
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5112434
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation	5103943
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5123459
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5118346
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5099526
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5123937
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation	5124663
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5124664
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5104364
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5133205
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5094554
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5104011
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation	5133206
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation	5075330
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5131202
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5136368

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	160	0
	600.0990	1	0	0
	600.0991	1	0	0
	600.1012	1	35	0
	600.1013	5	29	0
	646.2910	1	16	0
	646.3001	1	10	0
	646.3110	1	3	0
	646.3210	1	18	0

Plex 12/5/18 12:48 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

646.3301	1	5	0
646.3510	1	33	0
646.3511	1	33	0
646.3610	1	29	0
646.3710	1	42	0
646.3711	1	35	0
646.3712	1	31	0
646.3713	1	21	0
646.3714	1	15	0
646.3715	2	17	0
646.3716	1	29	0
646.3717	1	18	0
646.3718	2	22	0
646.3719	2	21	0
646.3810	2	28	0
646.3811	1	20	0
646.3812	2	20	0
646.3813	1	25	0
646.3910	4	77	0
646.3911	1	32	0
646.3912	4	73	0
646.3913	1	28	0
646.9410	1	90	0
647.0112	2	93	0
647.7703	2	14	0
650.9201	2	35	0
AN3-11A	10	209	0
AN3-12A	2	170	0
AN3-13A	1	86	0
AN3-3A	4	333	0
AN3-4A	10	267	0
AN3-5A	2	232	0
AN3-6A	2	162	0
AN316C4R	2	88	0
AN44-5A	2	59	0
AN4C7A	2	107	0
AN665-34R	2	50	0
CCR264SS3-02	36	875	0
CR3213-5-3	14	260	0
MS20426AD5-7	2	972	0
MS20470AD5-5.5	8	186	0
MS20470AD5-6	8	969	0
MS20470AD5-7	3	122	0
MS21042L08	2	1,829	0
MS21042L3	63	3,324	0
MS21042L4	2	2,906	0
MS21047-3	18	324	0
MS24693-C278	5	99	0
MS24694-S51	5	383	0
MS24694-S54	2	384	0
MS24694-S55	3	74	0
MS27039-08-13	2	538	0
MS27039-1-10	2	193	0
MS27039-1-12	6	196	0
MS27039-1-16	24	377	0
MS27039-1-19	22	413	0
MS27039-1-20	2	83	0
MS27039-1-21	4	78	0
NAS1149F0332P	144	3,834	0
NAS1149F0363P	2	525	0
NAS1149F0432P	4	1,362	0
NAS1149FN832P	4	2,461	0

Part Specifications

Specifications could not be found.

Plex 12/5/18 12:48 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:					

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF AEROSPACE INDUSTRIES, INC. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE EXPLICIT WRITTEN PERMISSION OF AEROSPACE INDUSTRIES, INC. IS PROHIBITED.

NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2. INSTALL F/N 14 WITH F/N 52 & 53.

3. 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASER-CARR P/N 75935A651.

4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5. REUSE FASTENERS FROM F/N 1.

6. USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7. AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9. NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	78	601.3875	SCREW	MS27039-1-10				
1	1	1	77	646.9410	SHIM		AN3-12A			
	4	4	76	601.2764	WASHER	MS27039-1-10				
	2	2	75	601.2973	LOCKNUT	MS27042-08				
	2	2	74	601.2988	SCRFW	MS27039-0813				
	2	2	73	601.2943	LOCKNUT	MS27042-2				
	2	2	72	601.3128	NUT	AN316C4R				
	2	2	71	601.3209	LOCKNUT	MS21042L4				
	4	4	70	601.2638	WASHER	MS211490423P				
	2	2	69	601.2669	BOLT	ANAC7A				
	2	2	68	601.3119	CLEVIS	AN565-34R				
	2	2	67	601.3121	EYE BOLT	AN546-5A				
	2	2	66	650.9201	EYE BRACKET ASSY					
REF	REF	REF	65	647.5701	GPS MOUNT KIT		AN3-12A			
		2	64	601.3151	WASHER	MS211490363P				
		2	63	601.2911	SCREW	MS246164553				
	24	24	62	601.2637	SCREW	MS27039-1-16				
2	2	2	61	601.2763	BOLT	AN3-12A				
	1	1	60	646.3913	SHIM					
	4	4	59	646.3912	SHIM					
	1	1	58	646.3911	SHIM					
	4	4	57	646.3910	SHIM					
	5	5	56	600.1013	PRIMER					
	8 FT	8 FT	55	600.0129	VHB TAPE					
	1	1	54	600.1012	SEALANT	PR-105 CLASS B				
	1	1	53	600.0991	MAGNORON 6398 PART B					
	1	1	52	600.0990	MAGNORON 6398 PART A					
6	10	10	51	601.2826	BOLT	AN3-11A				
		2	50	646.3814	WIPER BRACKET					
		2	49	601.2910	SCREW	MS27039-1-18				
	2		48	601.1365	SCREW	MS27039-1-10				
	2		47	646.3719	DOUBLER					
		2	46	646.3718	CUSTOM WASHER					
	1		45	646.3717	DOUBLER					
	22	2	44	601.1948	SCREW	MS27039-1-19				
	2	2	43	601.1952	SCREW	MS27039-1-20				
	4	4	42	601.1956	SCREW	MS27039-1-21				
4006	4005	4004	4003	4002	4001	FINO #	PART #	DESCRIPTION	MATL	SPEC.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 0219, 0221, 0222 & 0225	02/08/2010	P. BRAVO
B	INCORPORATED CN 0306, 0309 & 0431	11/04/2014	P. BRAVO
C	INCORPORATED ECN 0508	09/05/2015	P. BRAVO